

## PROAIR CLEAR

**DESCRIPTION:** The **Lesonal™** ProAir Clear is an acrylic urethane clearcoat for use over Lesonal Basecoat SB and intended for applications in cross flow and air-dry conditions. ProAir Clear offers excellent resistance to surface contamination with excellent gloss, making it an ideal choice for air dry environments.

### PRODUCT & ADDITIVES:

**MAIN PRODUCT:** — **Lesonal™** ProAir Clear



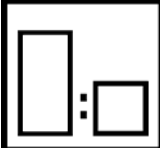



**HARDENERS:** — **Lesonal™** ProAir Clear Slow Hardener: a general-purpose slow hardener for larger areas and overall refinishing. Temperatures of 60°F-105°F (16°-38°C).  
 — **Lesonal™** ProAir Clear Fast Hardener: a general purpose fast hardener for medium and spot and panel repairs. Temperatures of 60°F-90°F (16°-32°C).

**ADDITIVES:** — **Lesonal™** Flex Additive: additive to increase flexibility for use on flexible parts.  
 — **Lesonal™** Accelerator: a catalyst additive, providing faster hardening of the ProAir Clear.  
 — **Lesonal™** Mat Clear: a special clearcoat with a mat finish. The gloss of Lesonal ProAir Clear can be reduced with blending of Lesonal Mat Clear.

### BASIC RAW MATERIALS:

— **Lesonal™** ProAir Clear: acrylic resin.  
 — **Lesonal™** ProAir Clear Fast Hardener: polyisocyanate resins.  
 — **Lesonal™** ProAir Clear Slow Hardener: polyisocyanate resins.

### APPLICATION:

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|----|---|---|----|---|--|
| 1. |  | Contains acrylic resins, methyl ethyl ketone, methyl amyl ketone and other ingredients. When mixed with hardener also contains polyisocyanates. | 4. |  | 2 Coats<br>Siphon Feed: 1.6–1.8mm<br>0.063"–0.070"<br>Gravity HVLP: 1.3–1.5mm<br>0.051"– 0.059"          |
| 2. |  | <b>3:1</b><br>3 Parts ProAir Clear<br><br>1 Part ProAir Clear Fast Hardener<br>or<br>1 Part ProAir Clear Slow Hardener                          | 5. |  | 5-10 minutes at 70°F (20°C)  |
| 3. |  | Mixing Stick # 7  | 6. |  | <b>Fast Hardener:</b><br>2-3 Hours at 70°F (20°C)<br><br><b>Slow Hardener:</b><br>8 Hours at 70°F (20°C) |



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**SUITABLE SURFACES:**

- Lesonal™ Polyurethane Topcoats when accelerated.
- Lesonal™ Basecoat SB.
- Existing finishes that have been sanded and cleaned.

**MIXING RATIO:**

**Mixing Stick # 7**  
 3 parts by volume of ProAir Clear, with  
 1 part of ProAir Clear Fast Hardener or ProAir Clear Slow Hardener

**SPRAYING VISCOSITY:**

13–15 seconds DIN Cup #4 at 70°F (20°C)

**POT LIFE:**

ProAir Clear Fast Hardener: 3–4 Hours at 70°F (20°C)  
 ProAir Clear Slow Hardener: 3–4 Hours at 70°F (20°C)

**SPRAY GUN & PRESSURE:**

	Fluid Tip	Spraying Pressure
Siphon Feed	1.6–1.8 mm 0.063"–0.071"	40–50 psi (3–4 bar)
Gravity Feed	1.4–1.6 mm 0.055"–0.063"	40–50 psi (3–4 bar)
Siphon HVLP	1.8–2.2 mm 0.071"–0.087"	Max 10 psi Max 0.8 bar
Gravity Feed HVLP	1.3–1.5 mm 0.051"–0.059"	max 10 psi max. 0.8 bar

**APPLICATION METHOD:**

Apply one single flowing coat. Allow the coat to flash 5-10 Minutes or until completely flashed-off. Apply a second flowing coat.

**NOTE:**

For larger vehicles and higher temperatures, 10% Lesonal Reducer can be added to improve flow and leveling.

**FLASH TIME:**

5–10 minutes at 70°F (20°C).

**DRYING TIMES:**

Below is a table showing the drying times of Lesonal ProAir Clear. The air-dry times stated may vary with insufficient airflow.

Metal Temp.	Drying	Fast Hardener	Slow Hardener
70°F (20°C)	Dust Free Tack Free Dry to Polish	10 min 30 min 2-3 hr	20 min 1 hr 8 hr



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**DRYING TIMES:** Below is a table showing the drying times of Lesonal ProAir Clear and the addition of 2-4 capfuls or ½ -1 ounce per sprayable quart of Lesonal Accelerator. When temperatures are below 70°F, Lesonal Accelerator is highly recommended to reduce surface contamination.

<b>Metal Temp.</b>	<b>Drying</b>	<b>Fast Hardener</b>	<b>Slow Hardener</b>
70°F (20°C)	Dust Free Tack Free Dry to Polish	5 min 20 min 1-2 hr	10 min 40 min 3-4 hr

**RECOATABILITY:** Lesonal™ ProAir Clear can be recoated with itself at any stage. Sanding will become necessary after 24 hours.

**FLEXIBLE PARTS:**

Mix ProAir Clear (5:1) with Lesonal Flex Additive before adding the appropriate hardener. (See Flex Additive technical data sheet.)

**FILM**

**THICKNESS:**

Approximately 1.2–1.5 mils per single coat.

**POLISHING:**

Dust and minor imperfections can be polished out after the “Dry to Polish” times listed under “Drying” have been reached.

Carefully sand out dust particles with # P-1500 grit paper wet, and then polish the area manually or mechanically.

**COVERAGE RATE:**

Approximately 270 sq. ft./liter per coat of unmixed paint.

**DECALS:**

Decals can be applied after 48 hours at 70°F (20°C)

**LETTERING:**

Hand stripping or lettering must be applied within 48 hours for good adhesion. After 48 hours, scuff with a gray scuffing pad.

**STOCK KEEPING:**

**COLOR:**

Clear

**SHELF LIFE:**

— Lesonal™ ProAir Clear: Two years if stored unopened at room temperature.  
— Lesonal™ ProAir Clear Hardeners: One year if stored unopened at room temperature.



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### SAFETY ASPECTS:

#### READY TO SPRAY VOC:

(3:1:1)

When mixed ready to spray,

**Lesonal™** ProAir Clear yields a VOC content of:    3.95 - 3.96 lb/gal  
474 - 475.2 g/liter

#### NOTICE:

Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on the Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends

the

use of protective equipment when mixing and spraying this material. Protect skin with gloves and spray suits, wear safety glasses or goggles when mixing, and wear full hood fresh air fed respirator while spraying.